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# Consumer Protection Programs

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PROCUREMENT SECTION  
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## Program Issuances For The Period

6-14-70 - 6-27-70







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UNITED STATES DEPARTMENT OF AGRICULTURE

Martel DU 8-3285

McDavid DU 8-4026

Washington, June 15, 1970

USDA Proposes Composition and Labeling Standards for Meat Patties:

The U.S. Department of Agriculture today announced a proposal to set specific standards of composition for Federally inspected meat patties and patty mixes and to require informative labels on their containers.

The proposal would enable buyers to know the specific ingredients in the patties and if, for example, they contain water or an "extender" such as cereal.

Under the proposed amendment to Federal meat inspection regulations, Federal, State and local regulatory officials would have better guidelines to help reduce deception in the sale of these products to consumers.

Composition standards would be set for various kinds of meat patties and mixes. For instance, a product to be labeled a "beef patty" or a patty mix to be labeled "beef and veal" would have to contain only chopped raw meat of the kind shown on the label and not more than 30 percent fat. Condiments necessary for adequate seasoning would be allowed.

Patties that contain other ingredients, such as water, cereal, nonfat dry milk, or soya flour, would have to bear labeling to indicate these additions. For example, a product in this category might be labeled "Beef and Veal Patty -- Cereal and Water Added," and would have to be within specific composition limits and comply with a maximum fat limitation of 30 percent.

Shipping containers for patties with larger proportions of added ingredients than permitted in the proposed standards would have to be labeled to show each significant ingredient present. This would be part of the product name, with the largest ingredient first and the smallest last, for example, "Patties - beef, beef spleen, water, soya flour, and nonfat dry milk."

Anyone wishing to comment on this proposal should send two copies of any statement to the Hearing Clerk, Room 112-A, U.S. Department of Agriculture, Washington, D. C. 20250 before July 17. All comments will be available for public inspection. The proposal will be published in the June 17 issue of the Federal Register.

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\*SDA 1823-70



UNITED STATES DEPARTMENT OF AGRICULTURE

McDavid DU 8-4026

Washington, June 19, 1970

Federal Meat Inspection Suspended at Arkansas Plant:

The U. S. Department of Agriculture announced today that Federal meat inspection has been suspended at Nat Buring Packing Co., Wilson, Ark., effective June 17.

USDA's Consumer and Marketing Service said that sanitation and facilities in the plant did not meet Federal requirements.

Officials said the plant is not entitled to slaughter or process meat for interstate shipment, or to use the Federal inspection mark while the suspension is in effect. Arkansas State inspection officials were notified of the Federal suspension and have promised to cooperate fully.

Inspection service was suspended at the plant under provisions of the Federal Meat Inspection Act and the regulations issued under it. They require, in part, that all meat and meat products shipped in interstate and foreign commerce must be inspected before and after slaughter, and that plants and facilities be operated under sanitary conditions.



UNITED STATES DEPARTMENT OF AGRICULTURE

McDavid DU 8-4026

Washington, June 25, 1970

Federal Meat Inspection Reinstated at Minnesota Plant:

The U.S. Department of Agriculture announced today that Federal meat inspection was reinstated at Spencer Foods, Inc., 209 N. 5th Street, Minneapolis, Minn., effective June 23.

USDA's Consumer and Marketing Service said inspection service was reinstated after an examination disclosed that sanitation and facilities in the plant now meet Federal inspection requirements.

Inspection service had been suspended June 17 (press release USDA 1887-70), when the plant was found to be operating under unsanitary conditions, officials said.

The Federal Meat Inspection Act and regulations, under which the inspection program is administered, require that all meat and meat products shipped in interstate and foreign commerce must be inspected before and after slaughter, and that plants and facilities be operated under sanitary conditions.





UNITED STATES DEPARTMENT OF AGRICULTURE  
CONSUMER AND MARKETING SERVICE  
WASHINGTON, D.C. 20250

Consumer and Marketing Service  
HUMANELY SLAUGHTERED LIVESTOCK

Identification of Carcasses; Changes in Lists of Establishments

Pursuant to section 4 of the Act of August 27, 1958 (7 U.S.C. 1904), and the statement of policy thereunder in 9 CFR 381.1, the lists (35 F.R. 2895, 4976, 5594, and 7457) of establishments which are operated under Federal inspection pursuant to the Federal Meat Inspection Act (21 U.S.C. 601 et seq.) and which use humane methods of slaughter and incidental handling of livestock are hereby amended as follows:

The reference to sheep with respect to Jack Agee & Co., Establishment 2281, is deleted.

The following table lists species at additional establishments and additional species at previously listed establishments that have been reported as being slaughtered and handled humanely.

Name of establishment	Establishment No.	Cattle	Calves	Sheep	Goats	Swine	Horses	Mules
Linden Packing Co., Inc.	45	(*)						
Insel and Insel	54	(*)	(*)					
Midtown Veal & Mutton Co., Inc.	612	(*)		(*)				
Carteret Abattoir, Inc.	639	(*)	(*)	(*)	(*)			
The Allen Packing Co.	845	(*)	(*)	(*)				
Shamrock Beef Co.	987	(*)						
Jack Polen Beef Co., Inc.	5548	(*)						
Cedar Packing Co.	6118	(*)						
Cribbs Sausage Co.	7424					(*)		
Blue Ridge Beef Plant, Inc.	7445	(*)						
New establishments reported: 10.								
Fresno Meat Packing Co.	354		(*)					
Piute Packing Co.	550			(*)				
Springfield Dressed Beef, Inc.	2590			(*)				
Double A Meat Packing, Inc.	5162			(*)				
Cessnun Abattoir	7082		(*)					
Species Added: 5.								

Done at Washington, D.C., on June 9, 1970.

G. H. WISE,  
Deputy Administrator, Consumer Protection.

[F.R. Doc. 70-7357; Filed, June 11, 1970; 8:48 a.m.]





UNITED STATES DEPARTMENT OF AGRICULTURE  
CONSUMER AND MARKETING SERVICE

WASHINGTON, D.C. 20250

[ 9 CFR Parts 301, 303 ]

MEAT INSPECTION

Notice of Proposed Rule Making

There appeared in the *FEDERAL REGISTER* (34 F.R. 13194) of August 14, 1969, proposed regulations for the implementation of the Federal Meat Inspection Act, as revised by the Wholesome Meat Act (21 U.S.C. 601 et seq.). Numerous comments were received from interested persons relating to the proposed definition of a retail store and other proposed provisions relating to exemption of certain retail operations. In light of these comments, alternative provisions as set forth below are under consideration in the Department.

Notice is hereby given in accordance with the administrative procedure provisions in 5 U.S.C. § 553, that pursuant to the Federal Meat Inspection Act, the Consumer and Marketing Service proposes to amend the Federal meat inspection regulations (9 CFR, Chapter III, Subchapter A) as follows:

In lieu of the provisions contained in §§ 301.2(ddd) and (eee) and in §§ 303.1(c) (2) and (3) and the first sentence in § 303.1(d) in the August 14, 1969, proposal, it is proposed to:

1. Add §§ 301.2 (ddd), (eee), (fff), and (ggg) to read as follows:

§ 301.2 Definitions.

\* \* \* \* \*

(ddd) *Retail Store.* Any place of business where the sales of product are made to consumers only; at least 75 percent, in terms of dollar value, of total sales of product represents sales to household consumers; only federally or State inspected and passed product is handled or used in the preparation of any product; no sale of product is made in excess of a normal retail quantity as defined in § 303.1(c)(3) of this subchapter; the preparation of products sold to household consumers is limited to traditional and usual operations as defined in § 303.1(c)(2) of this subchapter; and the preparation of products sold to other than household consumers is limited to traditional and usual operations as defined in subdivisions (i), (ii), (iv), and (v) of § 303.1(c)(2) of this subchapter. This definition includes any delicatessen or caterer's establishment that meets the conditions specified in this paragraph.

(eee) *Restaurant.* Any establishment where product is prepared only for sale or service, in meals, or as entrees, directly to individual consumers at such establishment; no sale of product is made in excess of a normal retail quantity as defined in § 303.1(c)(3); and the preparation of product is limited to traditional and usual operations as defined in § 303.1(c)(2) of this subchapter.

(fff) *Similar retail-type establishment.* Any establishment which is a combination retail store and restaurant; or other establishment as determined by the Administrator in specific cases.

(ggg) *Consumer.* Any household consumer, hotel, restaurant, or similar institution as determined by the Administrator in specific cases.

2. Add new § 303.1(c) (2) and (3) to read as follows:

§ 303.1 Exemptions.

\* \* \* \* \*

(c) \* \* \*

(2) For purposes of subparagraph (1) of this paragraph, operations of types traditionally and usually conducted at retail stores and restaurants are the following:

(i) Cutting up, slicing, and trimming carcasses, halves, quarters, or wholesale cuts into retail cuts such as steaks, chops, and roasts, and freezing such cuts.

(ii) Grinding and freezing products made from meat.

(iii) Curing, cooking, smoking, or other preparation of products not within subdivisions (i) or (ii), except slaughtering, rendering or refining of livestock fat or the retort-processing of canned products.

(iv) Breaking bulk shipments of products.

(v) Wrapping or rewrapping products.

(3) For purposes of subparagraph (1) of this paragraph, any quantity of product purchased by a consumer from a particular retail supplier shall be deemed to be a normal retail quantity if the quantity so purchased does not in the aggregate exceed one-half carcass in any calendar month in the case of purchases by a household consumer and one-half carcass in any calendar week in the case of purchases by any other consumer.

3. Insert the following in lieu of the first sentence in § 303.1(d): "The adulteration and misbranding provisions of the Act and the regulations in this subchapter, other than the requirement of the official inspection legend, shall apply to articles which are exempted from inspection or not required to be inspected under this section, including but not limited to a requirement that the preparation of any product containing pork shall include compliance with any applicable requirement for the destruction of trichinae as provided in Part 318 of this subchapter."

Any interested persons who desire to present any views, arguments, or data concerning the proposed amendments of the regulations set forth above may do so by filing their comments in writing, in duplicate, with the Office of the Hearing Clerk, U.S. Department of Agriculture, Washington, D.C. 20250, within 30 days after publication hereof in the FEDERAL REGISTER. All such written comments will be made available for public inspection at said office during regular office hours in a manner convenient to the public business (7 CFR 1.27(b)).

Done at Washington, D.C., on June 9, 1970.

RICHARD E. LYNCH,  
*Assistant Secretary.*

[F.R. Doc. 70-7399; Filed, June 12, 1970;  
8:47 a.m.]

UNITED STATES DEPARTMENT OF AGRICULTURE  
CONSUMER AND MARKETING SERVICE

WASHINGTON, D.C. 20250

**[ 9 CFR Part 328 ]**

**MEAT FOOD PRODUCTS**

**Definitions and Standards of Composition and Labeling of Meat Patties and Mixes**

Notice is hereby given in accordance with the administrative procedure provisions in 5 U.S.C. 553, that pursuant to the authority conferred by the Federal Meat Inspection Act (34 Stat. 1260, as amended by 81 Stat. 584, 21 U.S.C. sec. 601 et seq.), it is proposed to amend, as indicated below, Part 328 of the Meat Inspection Regulations (9 CFR Part 328).

*Statement of considerations.* The Department of Agriculture's standard for meat in the form of "Hamburger" prohibits the addition of extenders, such as cereals and meat byproducts. Hamburger must consist of meat that does not contain more than 30 percent fat. Only seasoning may be added. It has been found that meat patties containing meat byproducts, higher levels of fat, added water and various extenders, are sometimes sold to the public as "Hamburgers" at local outlets, such as retail stores, lunch counters and drive-ins. State and local food inspection officials have responsibility for preventing such deceptive practices. The Department believes that descriptive labeling of federally inspected meat patty products would help in controlling this problem.

The regulation would divide meat patty products into three distinct categories, based on composition, and establish rules for determining the product names that may be used in each category.

In general, the name would show the form of the product, such as "Patty" or, in the case of bulk product, "Patty Mix," and the kinds of meat or other ingredients used.

The first category would consist of products made only from seasoned, chopped raw meat with not more than 30 percent fat. These products would bear names showing the kind of meat used, such as "Beef Patty" or "Beef Patty Mix."

The second category would cover products containing chopped raw meat, seasoning, not more than 30 percent fat, not more than 3 percent added water and cereal adequate for binding. These products would bear names, such as "Beef Patty-Cereal and Water Added" or "Beef Patty Mix-Cereal and Water Added."

The last category would provide for labeling of patty products that do not meet the compositional restrictions of the first two with names that describe the kind of meat, meat byproducts, and other significant ingredients from which the product is made.

Part 328 of the Meat Inspection Regulations (9 CFR Part 328) would be amended by adding thereto a new § 328.4 to read as follows:

**§ 328.4 Meat patties and meat patty mixes and similar products; labeling, definitions, and standards.**

(a) *General label requirements.* The immediate containers of all products in

**PROPOSED RULE MAKING**

the form of patties or patty mixes shall be labeled so as to show in the product name the form of the products, i.e., patties or patty mixes and the kind or kinds of meat or other product used. All ingredients shall be shown in the ingredient statement on the label as required by § 317.2 and the labeling shall otherwise comply with this section and Part 317 of this chapter.

(b) *Definition and standard for products with unqualified kind name.* Patties or patty mixes which are labeled with the unqualified kind name, e.g., "Beef Patty" or "Beef and Veal Patty Mix," shall consist only of chopped raw meat of the kind or kinds indicated on the label and not more than 30 percent fat (which may include added fat) and condiments in amounts adequate for seasoning.

(c) *Definitions and standards for products with qualified kind name; special label requirements.* (1) Patties or patty mixes which contain chopped raw meat, not more than 30 percent fat (which may include added fat), condiments in amounts adequate for seasoning, and

(i) No more than 3 percent water; or

(ii) No more than 3 percent water and no more than 3½ percent, individually or collectively, of cereal, vegetable starch, starchy vegetable flour, soya flour, soya protein concentrate, nonfat dry milk, calcium reduced dried skim milk, or dried milk; or

(iii) No more than 3 percent water and no more than 2 percent, individually or collectively, of isolated soy protein concentrate or textured vegetable protein, shall be labeled to show, in the product name, the common name of any ingredients listed in subdivisions (i), (ii),



or (iii) of this subparagraph contained in the products, e.g., "Beef and Veal Patty-Cereal and Water Added," in addition to other labeling information required by paragraph (a) of this section.

(2) Patties or patty mixes which contain any meat or other meat product but do not meet the compositional requirements of paragraph (b) or subparagraph (1) of this paragraph (c) of this section shall be labeled so as to show in the product name the common name of each significant ingredient in the descending order of the proportion in which it is present in the product, e.g., "Patties-Beef, beef spleen, water, soya flour and nonfat dry milk" or "Patty Mix-Beef, beef spleen, water, soya flour, and nonfat dry milk." In addition, the label shall show other labeling information required by paragraph (a) of this section.

(d) If patties are cooked or partially cooked products, the composition of the raw mix from which they were prepared shall be used in determining whether they meet the requirements of paragraph (b) or (c) (1) of this section.

Any person who wishes to submit written data, views, or arguments concerning the proposed amendments may do so by filing them in duplicate with the Hearing Clerk, U.S. Department of Agriculture, Washington, D.C. 20250, within 30 days after the publication of this notice in the *FEDERAL REGISTER*. All written submissions made pursuant to this notice will be made available for public inspection at the Office of the Hearing Clerk during regular business hours (7 CFR 1.27(b)).

Done at Washington, D.C., on June 11, 1970.

RICHARD E. LYNG,  
*Assistant Secretary.*

[F.R. Doc. 70-7524; Filed, June 16, 1970;  
8:46 a.m.]

UNITED STATES DEPARTMENT OF AGRICULTURE  
CONSUMER AND MARKETING SERVICE  
WASHINGTON, D.C. 20250

**Title 9—ANIMALS AND  
ANIMAL PRODUCTS**

**Chapter III—Consumer and Marketing  
Service (Meat Inspection), Depart-  
ment of Agriculture**

**SUBCHAPTER A—MEAT INSPECTION  
REGULATIONS**

**PART 307—FACILITIES FOR  
INSPECTION**

**Overtime Work of Meat Inspection  
Employees**

On April 30, 1970, there was published in the *FEDERAL REGISTER* (page 6856, Doc. 70-5323) an amendment to the Federal meat inspection regulations relating to the change of fees for overtime work of meat inspection employees. The words "on any Saturday, Sunday, or holiday, or for more than 8 hours" were inadvertently omitted.

Section 307.4 is corrected to read as follows:

**§ 307.4 Overtime work of meat inspection employees.**

The management of an official establishment, an importer, or an exporter desiring to work under conditions which will require the services of an employee of the program on any Saturday, Sunday, or holiday, or for more than 8 hours on any other day, shall, sufficiently in advance of the period of overtime, request the inspector in charge or his assistant to furnish inspection service during such overtime period, and shall pay the Administrator therefor \$8.40 per hour to reimburse the Service for the cost of the inspection services so furnished. It will be administratively determined from time to time which days constitute holidays.

(34 Stat. 1264, Sec. 306, 46 Stat. 689; 19 U.S.C. 1306, 21 U.S.C. 89)

Done at Washington, D.C., on June 15, 1970.

ROY W. LENNARTSON,  
*Administrator.*

[F.R. Doc. 70-7757; Filed, June 18, 1970  
8:48 a.m.]






INFORMATION FOR: Regional Directors, Federal/State Cooperation  
Officers, State Officials, Other Government  
Agencies Officials

State Inspected Plants Eligible to  
Bid on Contracts Offered by Government Agencies

The attached is an updated listing of State inspected plants identified as having been certified by the Consumer Protection Programs as being "at least equal to" Federal meat inspection requirements and standards. Therefore, these plants are eligible to bid on contracts offered by those government agencies which have agreed to purchase meat products from such sources--namely Veteran's Administration and the U. S. Army.

This listing will periodically be updated as changes occur.

This notice supersedes CP Notice 35.



G. H. Wise  
Deputy Administrator  
Consumer Protection Programs

Attachment

Arizona

Tempe Meat Co.  
Priest Road  
Tempe, Ariz.

California

All Plants

Florida

All Plants

Maryland

All Plants

Minnesota

\*-Marks Company  
241 23rd Avenue, N.  
Minneapolis, Minn. 55411

Missouri

Baker Packing Company  
Highway 22 West  
P. O. Box 318  
Mexico, Mo. 65265

Bouckaert Packing  
218 Sidney  
St. Louis, Mo. 63104

Center Locker  
Center, Mo. 63436

Central Packing Co.  
P. O. Box 97  
Cape Girardeau, Mo. 63701

Community Locker Service  
201 N. Lyon  
Butler, Mo. 64730

Deep Freeze  
Highway 67 S.  
Poplar Bluff, Mo. 63901

Missouri (cont'd)

Forest City Packing Co.  
Highway B. East  
St. James, Mo. 65559

Frick's Slaughter  
P. O. Box 182  
805 S. Locust St.  
Washington, Mo. 63090

\*-Lebanon Packing Co.  
Lebanon, Mo. 65536

Maryville Packing Co.  
909 E. 7th  
Maryville, Mo. 64468

Murphy's Slaughter  
RR #2  
Farmington, Mo. 63640

Norv's Pork Products  
132 Pottery Road  
Washington, Mo. 63090

Ogden Abattoir  
1001 W. Washington  
Vandalia, Mo. 63382

Paige Packing  
4220 Natural Bridge  
St. Louis, Mo. 63115

Palazzolo  
5249 Loughborough  
St. Louis, Mo. 63107

Piekutowski  
4100 N. Florissant  
St. Louis, Mo. 63107

Poo's Locker  
11 E. Third  
Lees Summit, Mo. 64063

Randy's Frozen Meats  
310 W. Monroe  
Mexico, Mo. 65265

Missouri (con'd)

Rosser's Meat Co.  
109 E. Broadway  
Hannibal, Mo. 63401

Schnakenbergs Slaughter  
RR #3  
Concordia, Mo. 64020

Southtown Meat  
2623 Main St.  
Joplin, Mo. 64801

Star Packing  
3927 Cote Brilliante Ave.  
St. Louis, Mo. 63113

Toscano Ravioli  
2201 Macklind  
St. Louis, Mo. 63110

Nevada

\*-Las Vegas Sausage Co.  
2603 S. Highland Drive  
Las Vegas, Nevada 89102

\*-New York Meat and Provision  
Company  
2760 S. Highland Drive  
Las Vegas, Nevada 89102

New Mexico

Great Western Meat Co.  
912 Broadway, N. E.  
Albuquerque, New Mex.

Harrison Meat Co.  
601 South Miller  
Farmington, New Mex.

Hughes Meat Co.  
2901 Girard, N. E.  
Albuquerque, New Mex.

Mac's Meat  
1335 Idaho  
Las Cruces, New Mex.

New Mexico (cont'd)

Curry County Meat Co.  
Clovis, New Mex.

Santa Fe Meat Co.  
Santa Fe, New Mex.

Oklahoma

\*-H & R Meat Co.  
3920 E. Pine  
Tulsa, Okla. 74115  
Mailing Address:  
P. O. Box 1236  
Tulsa, Okla. 74101

Randy's Frozen Foods, Inc.  
321 E. 6th Street  
Okmulgee, Okla.

\*-Santa Fe Packing Co.  
1509 N. Main, Rte. 1  
P. O. Box 46-B  
Muskogee, Okla. 74401

Wickham Packing Co.  
Main St., Highway 66  
P. O. Box 286  
Sapulpa, Oklahoma 74066

Tennessee

\*-Custom-Pak Meats, Inc.  
2121 Dutch Valley Rd.  
Knoxville, Tenn. 37912

Utah

\*-M & M Wholesale Meat Co.  
9241 S. State St.  
Sandy, Utah 84070

\*-Midvale Packing Co.  
420 S. Main St.  
Midvale, Utah 84047

Utah (cont'd)

\*-Tri-Miller Company  
310 W. 400 North  
Hyrum, Utah 84319

West Virginia

\*-West Virginia Sausage Co.  
4th St., P. O. Box 478  
New Haven, West Virginia 25265







UNITED STATES DEPARTMENT OF AGRICULTURE  
Consumer and Marketing Service  
Consumer Protection Programs  
Washington, D. C. 20250

## MANUAL OF MEAT INSPECTION PROCEDURES

CHANGE: 35

June 27, 1970

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## PART 307 - FACILITIES FOR INSPECTION

307.1 "Due Notice" to the Officer in Charge regarding shipment of product from an official establishment will be worked out locally according to the needs of the establishment as well as that of the inspection service. When the Officer in Charge knows that the operating practices at an establishment meet acceptable standards, he may permit shipping and receiving of U. S. Inspected and Passed product during hours when an inspector is not on duty, subject to occasional unannounced checks. He may permit breaking of carcasses into quarters or primal cuts each bearing the mark of inspection. Unmarked product should be packaged and labels bearing the marks of inspection applied only while an inspector is on duty.

307.2 Supervisory inspectors will advise employees on matters relative to personal safety and the control and prevention of accidents. Division employees are not expected to initiate safety programs involving the employees of official establishments, but Division employees in supervisory capacities should include attention to safety factors when giving advice to establishments concerning plant facilities.

307.3 Information on equipment and facilities for the sanitary conduct of operations and inspection should be obtained from the pamphlet, "U. S. Inspected Meat Packing Plants."

307.5 The adequacy of lighting at inspection points should be determined by use of a light meter. The following minimum lighting intensities should be supplied before inspection is performed:

A. General Antè-Mortem Inspection. Ten foot-candles in the pens, alleys, or area where ante-mortem inspection is actually performed. Readings are taken three feet above the floor.

B. Suspect Pen. Twenty foot-candles over the entire suspect pen. If restraint facilities are separate, 20 foot-candles over these. Readings are taken three feet above the floor.

C. Head Washing Cabinet (Beef). Fifty foot-candles at the level of the head hook.

D. Beef Cervical (Head Rack). All areas of head illuminated to 50 foot-candles down to the symphysis of the mandible.

E. Beef Cervical (Head Chain). Fifty foot-candles at the lowest inspection point on the hanging heads.

F. Swine Cervical. Fifty foot-candles at the level of the mandibular lymph nodes of the lowest hanging heads.

G. Beef Viscera (Truck). Fifty foot-candles with meter resting at bottom of the pan of lower portion of truck.

Section 307.5

H. Viscera (Moving Top Table). Fifty foot-candles with meter resting in pan or on table top. (All species)

I. Rail Inspection. Fifty foot-candles at level of the shoulders. (All species)

J. Final Inspection. Fifty foot-candles at shoulder level, viscera pan, and head rack. (All species)

K. Carcass Coolers. Ten foot-candles at level of front shank of carcasses in cooler. Requirement does not apply to hot carcass coolers unless they are also used as a carcass holding cooler.

L. Offal Coolers. Twenty foot-candles general cooler illumination at lowest level of open product storage. Fifty foot-candles at packing point and reinspection area.

\*-307.6 Slaughter Rates at Federally Inspected Establishments. A rate of slaughter proposed by the official establishment or applicant for inspection will be shown on prints or specifications submitted for approval. The Technical Services Division will base its approval or disapproval of the plans on its judgment of the facilities and equipment needed to conduct a sanitary operation and to provide for inspection at the rate indicated.

Establishing rates of slaughter other than that on the approved blueprints shall be the responsibility of the Regional office. Factors that must be considered when a change in slaughter rates is requested by plant management should include the following:

A. Facilities and space for carcass dressing.

B. Facilities and space for ante-mortem and post-mortem inspection. If the company wishes to increase the rate of kill to a point where additional post-mortem inspectors are required, revised blueprints should be submitted to the Technical Services Division showing the inspection space provided.

C. Ability of the establishment to maintain sanitary dressing procedures.

D. Ability of the establishment to properly present the carcass and viscera for inspection.

E. Ability of the establishment to handle offal and inedible materials properly.

F. Availability of adequate employee welfare facilities.

G. Proper use of inspectional manpower (availability, work measurement, and manpower utilization).-\*



- \*- An up-to-date list of maximum permitted slaughter rates for each establishment should be on file in each Regional office and in the Slaughter Inspection Division office in Washington.

Actual kill rates shall not exceed the maximum permitted slaughter rate. When and where conditions prevail that make the maximum permitted slaughter rate too fast (i.e., poor sanitary dressing procedures, difficult dressing due to type of animal or time of year, prevalence of disease, etc.), inspection personnel at the establishment should require the maximum permitted slaughter rate to be lowered to permit production in accordance with required procedures.-\*



3. Such items may be used for spot application in areas other than processing, slaughtering or loading dock areas provided their use does not cause a nuisance such as dust contamination of product or equipment. Processing areas will include formulation, grinding, boning, cutting, smoking, curing and canning areas where exposed product is handled.

4. For spot application to absorb moisture, it will be necessary to remove the material when tracking into a prohibited area occurs.

\*- Z. The reuse of fiberboard, wood, or wire bound crates or other similar pervious containers is not permitted except that wrapped products prepared by locker and provisioner plants from carcasses or primal cuts owned by customers can be distributed in such containers when they are the property of the customer and visibly free of dirt, stains, or odors and completely lined with plastic sheeting or heavy gauge paper.-\*

308.13 Contaminants--Bacterial. The pusher bar of some frozen meat choppers feeds frozen blocks of meat to the chopping blade. There is a space of a quarter inch or more between the pusher bar and the bed of the chopper. The pusher bar should be removed at the close of a day's operation and thoroughly cleaned. It should be left unassembled and allowed to air overnight.

A. Sausage grinder plates of the so-called reversible type are constructed with removable bushings and sleeves. This permits the accumulation of a considerable amount of meat, fat, and meat juices on the inner surfaces of the various demountable parts during grinding operations. The parts must be completely demounted for cleaning daily.





## Section 308.14

responsibility for prompt reporting of all suspect cases of communicable disease among their employees to local health authorities.

## 308.15      Equipment--Care, Reconditioning.

A.      Properly equipped tables, sprays, and the like should be furnished wherever necessary for cleaning product that has accidentally become soiled.

B.      Equipment should be provided for receiving trolleys, gambrels, sticks, and smoke sticks for transfer to a suitably equipped place for cleaning before reuse.

C.      Since ozone masks odor, thereby interfering with inspection, equipment that produces ozone in appreciable amounts may be used only in coolers set aside solely for the aging of meat. Other operations requiring the continuing presence of inspectors and plant personnel should not be conducted in such coolers. The concentration of ozone in the air should not, at any time, exceed .1 ppm. Ozone generating equipment must be controlled to assure that this level is not exceeded, and measuring devices must be available to record the ozone concentration at any time. Prior to periods when inspections are performed, the ozone generating equipment must be shut off and the ozone in the air permitted to dissipate. All proposals for installation of ozone generating equipment should be referred to the Equipment Group, Technical Services Division.

D.      Unnecessary pipes, wires, strings, and other material should be removed and no trash should be allowed to accumulate.

E.      Cutting boards should be as small as is practical for the purpose. Such boards should be kept smoothly planed and removed daily for cleaning on all surfaces.

\*-F.      New carcass shroud cloths should be washed prior to use to remove loose material and lint. Shroud cloths should be washed after each use and thoroughly rinsed to assure removal of all soap and detergent compound.-\*

G.      Storage compartments of "snow ice," "flake ice," "pac-ice," and similar equipment should be lined with stainless steel or other rust-resisting metal. The metal should be of sufficient thickness to withstand repeated striking of a shovel without puncturing. Suitable perforated, rust-resisting, and removable metal drainage plates should be provided in the bottom of the ice storage compartment, and frequently inspected to assure their cleanliness. Some of the equipment used for the production of various forms of flaked ice is so constructed that the water resulting from the melted ice is collected in a space below the ice storage compartment. This water may not be used for the production of ice nor should it be permitted in potable water lines or supply. There is no objection to prechilling the water intended for the manufacture of ice by circulating it in closed coils submerged in the cold water beneath the storage compartment.

H.      Corrosion or rusting of metal equipment or surfaces may be prevented by frequent, thorough cleaning followed by the application of an anti-rust agent which is authorized as indicated in category (AA) of the

Section 308.15(H)

"List of Chemical Compounds." Equipment that is to come into contact with product must be washed or wiped, as required, in order to effectively remove any substance which could be transferred to food being processed.

I. Wooden secondhand containers that have been reconditioned prior to receipt at an establishment should not be accepted for use since it is impossible to give the inspection necessary to determine fitness for use as contemplated in Section 308.12(a) of the Meat Inspection Regulations. Wooden containers are frequently used in industry for various chemicals and insecticides, some of which are highly poisonous. Containers previously used to hold food may contain vermin excreta and decomposed material consisting largely of food spoilage organisms and dangerous toxins. As the complete removal of dangerous substances cannot be accomplished with certainty from containers made of porous material such as wood, such containers that show evidence of dangerous contamination should be rejected.

J. Secondhand containers made of nonporous material, such as steel drums intended as containers for edible rendered fat, may be reconditioned without prior inspection; however, inspectors should examine such containers very carefully to determine that effective cleaning and preparation for use has been accomplished. The inspection would include:

1. Wiping the inner surface of the container with a clean white cloth or towel to determine whether all former contents have been removed.
2. Looking for a spotted appearance of the inner surface which may be an indication that the new lining will not adhere over improperly cleaned old linings or rusty surfaces.
3. Looking for dents in chime and sides of drum. These areas should be free from damage that would interfere with satisfactory cleaning and inspection. In determining the acceptability of steel drums, inspectors should apply the usual product container requirements for cleanliness and absence of probable sources of contamination. The acceptability of the coating on the inner surface of any metal container can be determined by obtaining from the Management the name of the lining material, name and address of the firm that applied the coating, and forwarding this information to the Laboratory Branch of the Technical Services Division, Washington, D. C.

K. Common steel drums such as lard drums may be used only as containers for meat products other than edible rendered fats under the following conditions:

1. They may be used only as shipping containers. Drums are not to be used as operational containers for edible products in official establishments.
2. They must be acceptably galvanized.
3. The inside and outside of the drums must be free of rust and corrosion.
4. The body must be reasonably free of dents and distortion.

## PART 309 - ANTE-MORTEM INSPECTION

309.1 The purpose of ante-mortem inspection is to accept for human food only those animals that yield meat or meat food products that are healthful, safe from harmful chemical and drug residues and are consistent with the consumer's sense of decency. Achieving this purpose results in:

A. Removing from human food channels those animals having conditions undetectable on routine post-mortem inspection (chemical poisonings and diseases affecting the central nervous system).

B. Preventing unnecessary contamination of the slaughtering department by diseased animals.

C. Obtaining information on suspect animals for sound post-mortem carcass disposition.

D. Withholding from slaughter animals exhibiting abnormal conditions that make them unfit for human food.

309.2 Required Facilities and Equipment. An official establishment must furnish and adequately maintain the following facilities and equipment to enable the inspector to perform ante-mortem inspection on all animals presented for slaughter:

A. Covered and properly identified pens for segregating suspect and condemned animals. Covered restraining devices such as chutes, squeeze gates, boxes, or any other effective device for restraining animals requiring close examination.

B. Thermometers.

C. Establishment employees designated by management for sorting, restraining, moving, and identifying animals.

D. Covered pens in sufficient numbers to facilitate ante-mortem inspection in inclement weather.

E. When the official establishment serves both as a slaughtering facility and a public stockyard, separate pens must be designated for animals presented for ante-mortem inspection and those destined for resale. Ante-mortem inspection should only be performed on animals identified for slaughter by the establishment.

F. A walkway 48 inches or more above the pen floor with a 24-inch wide platform and equipped with a safety rail must be provided along the inside of the pen for ante-mortem inspection of horses.



\*-309.3

A. Sequence of Procedures for the Ante-Mortem Inspection of Cattle, Calves, Swine, Sheep, Goats, and Horses.

1. Inspection must be made on the day of slaughter, unless arrangements in accordance with Section 309.1 of the Regulations have been made.

2. Observe cattle, large calves, and horses when still or "at rest" from outside the pen. Conduct still or "at rest" inspection from inside the pen for small calves, swine, sheep, and goats.

3. Observe the animals "in motion" from both sides. A mirror may be used as an aid in this procedure. Animals should be as free from excitement as possible.

4. Sort out and segregate abnormal animals. Animals showing symptoms of disease (central nervous symptoms, inability to react normally to stimuli, abnormal temperature, dyspnea, etc.) or other abnormal conditions (injuries, swelling, etc.) are to be separated and placed in designated pens for examination by a veterinarian. The phase of ante-mortem inspection which consists of sorting and segregating animals exhibiting abnormal conditions can be performed by a veterinary medical officer or a food inspector under the supervision of a veterinarian.

5. Properly identify animals passed for regular slaughter and communicate information to post-mortem inspectors. An identification system of animals having received ante-mortem inspection and accepted for slaughter shall be established. Animals are not to be removed from pens and sent to slaughter unless a record (report or pen card) signed by the ante-mortem inspector certifying that inspection was performed is available to the post-mortem inspector prior to actual slaughter of the animal. The record shall have as a minimum the following information: Date, species, number, description of the animals, hour of inspection, lot or pen number, and signature of the inspector performing ante-mortem inspection.

The record is to be delivered to the inspector assigned to the slaughtering operation immediately prior to or at the time the animals are driven into the establishment for slaughter. Continual comparison between the number of animals certified on the record and the number of animals slaughtered shall be made throughout the day's kill to determine that all animals being slaughtered have received ante-mortem inspection. The ante-mortem inspection record of each day's kill shall be held at the establishment for 1 week. Modifications of this procedure to fit small, large, or unusual operations are acceptable provided they assure identification of all animals receiving inspection. Any modified system must be approved by the Regional Director. Supervisors shall continually check the procedure to determine that the goal of ante-mortem identification of all animals destined for slaughter is being met. -\*



\*-B. Sequence of Procedures for the Examination and Disposition of Abnormal Animals.

1. Restrain the abnormal animal.
2. Detailed examination by a veterinarian.
  - a. Take temperature, if necessary.
  - b. Palpation, if necessary.
  - c. Close observation.
3. Determine the proper ante-mortem disposition from the following:
  - a. Release the animal for slaughter without restriction (examination reveals no evidence of disease or other conditions).
  - b. Release the animal for slaughter as a U.S. Suspect (examination reveals a disease or condition which requires a more detailed examination by an inspector when slaughtered to determine its disposal).
  - c. Withhold the animal from slaughter as U.S. Condemned (examination reveals an animal in a dying condition, one affected with a condition or disease that would require condemnation of its carcass on slaughter, or one affected with a condition or disease that may be held for observation or treatment).
4. Identify the animal by tagging ("U.S. Suspect" or "U.S. Condemned").
  - a. In addition to tagging, the identification of U.S. Suspect swine must include the use of tattoos to maintain the identity of the animals through the dehairing equipment when such equipment is used.
  - b. When cattle affected with epithelioma of the eye, actinomycosis, or actinobacillosis are handled as provided in Section 309.18(a) of the Regulations, it will not be necessary to complete a separate Form CP-402-2, "Identification Tag - Ante-Mortem," for each individual animal. Instead, one 402-2 card shall be completed for each of the above conditions in the lot and the number of cattle affected with each condition recorded on the card. Such animals must, however, be handled as U.S. Suspects and identified during slaughter with the "U.S. Retained" multi-sectioned tag. They will further be recorded as U.S. Suspects on Form CP-403 and Form CP-403-6.-\*



\*-c. Animals made U.S. Suspects for other conditions shall be individually tagged and the clinical information and identifying number recorded on individual Form CP-402-2 cards and forwarded to the post-mortem inspector.

d. Animals identified as U.S. Condemned shall be handled in one of two ways:

(1) Promptly killed by the official establishment, if not already dead, and disposed of according to Part 314 of the Regulations.

(2) Withheld from slaughter with the condemned animal placed in an acceptable pen and held for observation or treatment. With the agreement of local, State, and/or Federal animal health officials, the animals can be transported to a location other than the official establishment. When an animal is condemned and is handled according to this procedure and recovers or a required withdrawal time is met, the animal, if returned for slaughter, must be reexamined on ante-mortem inspection by a veterinary medical officer and a disposition made as outlined in paragraph B(3).-\*

\* \* \*

#### 309.4 Ante-Mortem Inspection of Cattle with Proteolytic Enzymes.

A. Only animals showing no symptoms of disease or other abnormal conditions are to be injected with an enzyme solution prior to slaughter.

B. A minimum of 2 minutes and a maximum of 30 minutes should lapse between the injection and the time the animal is slaughtered. Animals showing any reactions following the injection are to be held for examination by the veterinarian.

Some reaction symptoms are salivation and incoordination at the time of injection, dyspnea, blood tinged froth at nose and mouth, rapid pulse, edema, and/or hyperemia of the throat area.

Veterinary meat inspectors may release the animal for slaughter after it is observed to be normal.

#### 309.5 Diseases and Conditions.

A. "Downers" are animals that are unable to stand or have abnormal changes in locomotion and should be withheld from slaughter for a period of 24 hours. After this period of time, if the animal is progressively weaker and/or the symptoms exhibited by the animals are more exaggerated, they should be marked as U.S. Condemned and handled according to Section 309.16 of the Regulations. These animals that are not condemned should be made a U.S. Suspect and the final disposition based on ante-mortem and post-mortem findings

along with a histopathological examination of tissue specimens of heart, brain, liver, kidney, spleen, and all diseased tissues. An exception to this are those animals exhibiting symptoms which indicate recent trauma or a localized condition that mechanically impairs the animal's movement. Such animals can be sent to slaughter as a U. S. Suspect provided any required withholding periods relative to drugs and chemicals have been met. "Downers" showing symptoms of a disease entity for which condemnation is required by the Regulations are to be marked as U. S. Condemned on ante-mortem. "Downers" condemned on ante-mortem which are held for treatment or observation in lieu of immediate destruction should be isolated and placed in facilities reserved for this purpose.

B. Animals exhibiting symptoms of certain disease conditions in addition to the ones listed in the Regulations should be condemned on ante-mortem inspection. This includes symptoms of central nervous system disorders in which animals are showing either a depressed (drowsiness, weakness, or coma) or an exaggerated activity (licking, staggering, circling, muscular tremors, etc.) These symptoms of central nervous system disfunction could indicate one of the following disease conditions:

1. Sporadic bovine encephalomyelitis.
2. Infectious Thromboembolic Meningo - encephalitis.
3. Salt poisoning.
4. Metal poisoning.
5. Fluorine poisoning.
6. Chlorinated hydrocarbon pesticide poisonings.
7. Organo-phosphorus pesticide poisonings.
8. Plant poisonings.

C. Calves lacking in vigor and muscular coordination as determined by lethargy and inability to stand and walk normally shall not be slaughtered for human food. Calves, regardless of age, that are determined on ante-mortem inspection to be satisfactorily developed and show normal movements and show no symptoms of disease may be passed for slaughter without restriction.

D. Diseases and conditions requiring special handling are as follows:

1. Emergency Slaughter. The provisions in the Meat Inspection Regulations for emergency slaughter are not intended to cover the slaughter of sick or dying animals. Also, animals for which a required drug or chemical withholding period has not been observed are not acceptable under the emergency slaughter provisions.



PART 310 - POST-MORTEM INSPECTION

310.1 Inspectors assigned to post-mortem duties shall observe the condition of rooms and equipment and the clothing of establishment employees to see that they are clean and that the equipment, including sterilizers, wash basins, and facilities for inspection, are in proper working order.

310.2 Each inspector performing post-mortem duties shall constantly observe the maintenance and use of sterilizers and wash basins during the day and require that they be properly maintained and used.

\*-In addition to all equipment and facilities contacting condemned material, the following items must be sanitized after use on each carcass: Dehorning device, weasand rod, brisket opening implement, swine head dropping knife, and swine carcass splitting saw when carcasses are split prior to viscera inspection. Establishment employees are also required to sanitize carcass dressing implements in 180° F. water after use on each U.S. Suspect and U.S. Retained carcass.\*-

When one of the following conditions exist, the viscera inspection truck shall be thoroughly cleaned and sanitized with 180° F. water:

- A. When contaminated with feces, ingesta, or urine.
- B. When contaminated with purulent exudate from a fluke infested liver or contaminated with pus or purulentlike exudate from an abscessed lung, liver, uterus or other viscera.
- C. When contaminated with viscera affected with acute or periacute conditions.
- D. When contaminated with viscera from a condemned carcass.
- E. After company breaks and lunch periods.

\*-In those cases, such as when a liver is condemned for telangiectasis, "sawdust," unopened abscess, or liver flukes, that do not result in the viscera truck being contaminated with visceral contents or infectious material, the viscera truck may be reused without sanitizing. However, to prevent fat buildup on the inspection truck, it should be periodically cleaned with hot water.\*-

When a viscera inspection truck is rinsed, the procedure shall not result in contaminating edible product or equipment. Cleaning with 180° F. water shall be performed in an approved area set aside for the purpose.

310.3 Certain areas have been provided and set apart for the exclusive use of inspectors. Establishment employees must not be permitted to encroach on such places to the detriment of inspection work.

310.4 \*-When it is necessary to tag a carcass on an initial inspection to indicate the condition found, the following methods, as applicable, shall be used:

A. Hogs. Tags, black only, shall be placed, as indicated below, for the applicable conditions on the side of carcass approaching the viscera inspector.

1. Tuberculosis (cervical): Belly lateral to xiphoid cartilage.
2. Slight cervical abscess: Foreshank.
3. Well-marked or extensive abscess: Axillary area.
4. Not to be opened: Midline above xiphoid cartilage.
5. Other conditions: Lateral to midline on belly.

B. Cattle. Condition identification shall be accomplished by letter coding the tag by pencil or ink only, such as: AC - Actinomycosis, AB - Abscess.-\*

310.5 The brands "U. S. Condemned" and "U. S. Passed for Cooking" are to be used for marking carcasses and parts. Informal marks and tags should not be substituted for these brands.

310.6 Inspectors are expected and required to make such incisions or inspections as are essential to determine the presence, character, and extent of any condition that might have a bearing on the disposition of the carcass or any of its parts. However, unnecessary mutilation of carcasses or parts that ultimately may be passed for food, and, of course, the unjustified condemnation of carcasses or parts, must be avoided.

310.7 When making inspections of nodes or organs requiring the use of a knife, it is essential that the tissues be sliced in such a way that the

## Section 310.7

exposed surfaces may be carefully examined. Hashing nodes by a hacking or chopping method which affords no opportunity to examine the cut surfaces is not acceptable.

310.8 The "final" inspector is the immediate supervisor of the slaughtering and related departments to which he is assigned. He is responsible for all matters pertaining to the inspection. This applies not only to the actual final inspection of retained carcasses but also to the sanitary condition of the premises, the condition and operation of equipment, and the work of employees who may be under his supervision. Matters involving structural changes or improvements are generally taken up with the Officer in Charge or his designated assistant.

310.9 Post-mortem inspection of U.S. Suspects should not be performed until the ante-mortem findings have been received by the post-mortem inspector.

310.10 \*-The routine (other than final inspection) post-mortem inspection of every carcass shall be conducted in accordance with the procedures and sequences shown in the four Slaughter Inspection post-mortem training films. These films are the standard for performance by post-mortem inspectors and for review purposes by the Washington staff. Variations from the sequences of inspection procedures shown in the films shall be acceptable provided no inspection procedures are omitted.

A general examination of the entire carcass (outer surfaces and exposed surfaces of cavities) and of the viscera must be included in the routine post-mortem inspection of every carcass, in accordance with the following:

### A. Cattle.

1. The methods employed in handling, stunning, shackling, and bleeding the animals shall be observed. (The animals shall be handled promptly.) The area where the stunned animals are discharged from the knocking box shall be kept clean and as dry as possible. When captive bolt stunners of the penetrating type are used over the frontal region, pieces of skin, hair, and bone are carried into the brain. When used at the base of the skull, they usually cause extensive hemorrhage in the area. This requires trimming of the neck after the carcass has been split. Hemorrhagic tissue and brains that are contaminated with foreign material shall be condemned.

### 2. Carcass spacing and handling of heads.

a. Cattle shall be sufficiently spaced or handled in a manner to prevent contact of skinned portions of adjacent carcasses by feet, hide, or any other source of contamination from the time of bleeding until after rail inspection. Indiscriminate bunching of carcasses prior to final carcass washing shall not be allowed.

b. The esophagus of cattle shall be effectively closed to prevent the escape of rumen contents.-\*

- \*-c. The esophagus shall be "rodded" or carefully separated from surrounding tissue in a manner to prevent contamination of the carcass.
- d. The heads shall be removed in a manner to avoid soiling them with rumen contents.
- e. The heads and corresponding carcasses shall be identified by duplicate numbered tags securely fastened by an establishment employee before the heads are removed.
- f. The skinned heads shall not be permitted to come in contact with the floor.
- g. All horns and pieces of hide must be removed before heads are washed.
- h. Equipment used for holding heads during trimming shall be periodically rinsed to preclude buildup of contamination.
- i. The washing of heads shall be done in compartments or areas which will control the splash of waste water.
- j. Heads shall not be allowed to contact the floor of the head wash cabinet.
- k. The nasal and oral cavities shall be thoroughly flushed before washing the outer surfaces of each head.

3. Sequence of procedures for the cervical inspection of cattle heads presented tongue in.

- a. Observe the external portions of the head and eyes.
- b. Incise and observe the cervical lymph nodes.
  - (1) Leading mandibular node.
  - (2) Leading parotid node.
  - (3) Leading atlantal node.
  - (4) Trailing atlantal node.
  - (5) Leading and trailing suprathyroid nodes.
  - (6) Trailing parotid node.
  - (7) Trailing mandibular node.-\*



\*- c. After the tongue is "dropped," incise and observe the muscles of mastication (cheeks).

- (1) Leading lateral muscle of mastication.
- (2) Leading medial muscle of mastication.
- (3) Trailing medial muscle of mastication.
- (4) Trailing lateral muscle of mastication.

d. Observe and palpate the tongue.

4. Sequence of procedures for the cervical inspection of cattle heads presented tongue out - base up.

a. Incise the cervical lymph nodes located on the tongue.

- (1) Leading supratharyngeal node.
- (2) Leading atlantal node.
- (3) Leading mandibular node.
- (4) Trailing supratharyngeal node.
- (5) Trailing atlantal node.
- (6) Trailing mandibular node.

b. Observe and palpate the tongue.

c. Observe the external portions of the head and eyes.

d. Incise the parotid lymph nodes and the muscles of mastication (cheeks).

- (1) Leading parotid node.
- (2) Leading lateral muscle of mastication.
- (3) Leading medial muscle of mastication.
- (4) Trailing medial muscle of mastication.
- (5) Trailing parotid node.
- (6) Trailing lateral muscle of mastication. -\*



\*-5. Sequence of procedures for the cervical inspection of cattle heads presented tongue out - tip up.

a. Incise the cervical lymph nodes located on the tongue.

- (1) Leading atlantal node.
- (2) Leading mandibular node.
- (3) Leading suprapharyngeal node.
- (4) Trailing suprapharyngeal node.
- (5) Trailing mandibular node.
- (6) Trailing atlantal node.

b. Observe and palpate the tongue.

c. Observe the external portions of the head and eyes.

d. Incise the parotid lymph nodes and the muscles of mastication (cheeks).

- (1) Leading parotid node.
- (2) Leading lateral muscle of mastication.
- (3) Leading medial muscle of mastication.
- (4) Trailing medial muscle of mastication.
- (5) Trailing parotid node.
- (6) Trailing lateral muscle of mastication.

6. Ulcers, scar tissue, and the tonsils shall be removed from the head or tongue by an employee of the establishment under the direction of the inspector. Lesions resembling actinobacillosis or actinomycosis shall be carefully examined by the inspector and incisions made, if necessary, to determine the character and extent of the lesions. Tongues affected with cactus thorns and/or cactus thorn abscesses shall be condemned for food under Section 311.9(d) of the Meat Inspection Regulations.

7. Removal, cleaning, and inspection of the head shall be completed before viscera inspection of the corresponding carcass is started.

8. Establishment employees shall take care to see that the skinning bed area is acceptably clean before the carcass is lowered. The head skin must be so manipulated that the tissues of the neck will be protected from soilage and other precautions must be taken to prevent\*

\*-contamination of any of the meat of the carcass. This may be best accomplished by leaving the ears on the hide and head skins tied except in "kosher dressing." The front and hind feet must be removed before any other incision is made in the carcass. In removing the front feet, care should be taken to expose as little as possible of the tissues of the foreshank and leave a "tie" of the hide completely covering the shank as far down as possible toward the carpal articulation where the cut is made to remove the foot, or the feet may be removed by a single transverse incision through the hide and articulation. When possible, cuts made to open hide should be made from inside outward. Pritch sticks must be used in such a manner as to not result in contamination of the carcass. When establishment employees move the carcass from the skinning bed, they must use care to see that the exposed parts of the carcass are protected from contact with the floor or with fixed objects. The floor of this area shall be maintained in a clean and sanitary manner, after each carcass is handled.

Care should be exercised when skinning animals by the on-the-rail type of dressing procedure so that the hide is always reflected away from the carcass starting with the hindshanks and proceeding downward. Cuts made to open hide should be made from inside outward. Lactating udders on any type beef slaughter operation shall be removed in such a manner as to prevent soilage of the carcass with udder contents. Any contamination from udder content must be immediately trimmed from the carcass. Unless udders are identifiable to the inspector until such time as the carcass passes inspection, the supramammary lymph nodes shall be left attached to the carcass until inspection is completed.

9. The **skinning** of the bung shall be made part of the rumping operation. The perineal skin shall be reflected laterally over the anus leaving the external sphincter muscle intact. The incision into the pelvic cavity to "ring" the bung shall be made with a clean knife. The rectum is then tied in such a manner as to tie off the neck of the bladder. When an establishment demonstrates it can consistently skin the perineal area, "ring" the bung and handle it in such a manner to prevent contamination to the carcass and viscera, the bung may be left untied, provided the bladder is removed and disposed of as the first operation of the evisceration procedure. A tie must be made at the point where the small intestine leaves the stomach and at the point where the esophagus attaches to the paunch, if edible fat or tripe is to be saved. At each of these two named points, two ties should be made about 4 inches apart with the contents being stripped from the intervening portion of the intestine or esophagus, respectively, before the second tie is made so that the tissues can be severed with a knife between the ties without any spillage of the contents. The hide over the tail shall be pulled directly after "ripping." Procedures at variance with the above may be accepted if the purpose of the requirements is fully accomplished.

10. Sequence of procedures for the viscera inspection of cattle viscera truck or moving top table.

a. If cattle are eviscerated into a viscera inspection truck, perform the sequence described under high rail -\*

\*-inspection, unless a rail inspector is provided, then observe the eviscerated carcass. If cattle are eviscerated onto a moving top table, observe the eviscerated carcass.

- b. Observe the mesenteric lymph nodes and abdominal viscera.
- c. Palpate and observe the rumino-reticular junction.
- d. Observe the esophagus.
- e. Observe the spleen.
- f. Incise and observe the lymph nodes of the lung.

- (1) Posterior mediastinal lymph node.

- (2) Middle mediastinal lymph node.

- (3) Anterior mediastinal lymph node.

- (4) Right bronchial lymph node.

- (5) Left bronchial lymph node.

- g. Open and observe the lumen of the bronchial tube when lungs are saved as edible product.

- h. Observe and palpate the dorsal (curved) surface of the lungs.

- i. Incise the heart and interventricular septum and observe the cut surfaces and inner surface of the heart. The heart may be incised from base to apex or vice versa. In some areas, the heart may be prepared and inspected as follows:

After the external surface of the heart has been inspected, the organ shall be prepared for further inspection by an establishment employee severing its attachments and cutting through the interventricular septum and such other tissues as will permit him to evert the organ completely. The inspector shall then examine the interior surfaces and make not more than four deep lengthwise incisions into the muscles of the septum and left ventricular wall, unless the presence of cysts is suspected, when more incisions shall be made. Under this method, care shall be taken not to cut completely through the walls of hearts to be passed without restriction. If necessary to maintain the identity of hearts, the establishment shall provide consecutively numbered tags and appropriately mark the carcasses and hearts.

- j. Turn the lungs over and observe the ventral (flat) surfaces of the lungs and the external surface of the heart.\*

\*- k. Incise and observe the hepatic (portal) lymph nodes.

l. Open the bile duct in both directions. Observe its contents.

m. Observe and palpate the ventral surface of the liver.

n. Turn the liver over, palpate the renal impression, and observe and palpate the parietal (dorsal) surface.

NOTE: Cattle liver inspection procedures may be performed prior to or after heart and lung inspection procedures. The beef heart may be incised and inspected prior to or after the lung inspection procedures.

11. Sequence of procedures for the rail inspection of cattle.

a. High rail inspection. Used with an "on-the-rail" system with a "drop-rail" eviscerating station or a "bed-dress" operation.

(1) Observe the back of the skinned carcass as it is being eviscerated.

(2) Palpate the superficial inguinal or supramammary lymph nodes.

(3) Palpate the internal iliac lymph nodes.

(4) Observe the lumbar region.

(5) Observe the body cavities.

b. Low rail inspection. Completes the rail inspection procedures started with high rail inspection. To be performed after the carcass is split, but prior to washing.

(1) Observe the cut surfaces of muscle and bone.

(2) Observe the pillars of the diaphragm.

(3) Observe the peritoneum.

(4) Observe and palpate the kidneys.

(5) Observe and palpate the diaphragm.

(6) Observe the pleura.

(7) Observe the neck muscles.

(8) Observe the outside of the carcass.-\*



\*-c. Complete rail inspection. Used with separate rail inspection station on a continuously moving line. To be performed after carcass is split, but prior to washing.

- (1) Palpate the superficial inguinal or supramammary lymph nodes.
- (2) Palpate the internal iliac lymph nodes.
- (3) Observe the lumbar region.
- (4) Observe and palpate the kidneys.
- (5) Observe the pillars of the diaphragm.
- (6) Observe the peritoneum.
- (7) Observe and palpate the diaphragm.
- (8) Observe the pleura.
- (9) Observe the cut surfaces of muscle and bone.
- (10) Observe the neck muscles.
- (11) Observe the outside of the carcass.

12. When lesions of actinomycosis or actinobacillosis are found in the head but not in the viscera, the incision of the body lymph nodes may be omitted. However, a careful survey of the carcass shall be made, including palpation of the region of the body lymph nodes for the detection of possible abnormal conditions. The anterior, middle, and posterior cervical lymph nodes shall be examined when lesions of actinomycosis or **actinobacillosis** are found in the viscera. When lesions of actinomycosis or actinobacillosis are found in the head, the cervical lymph nodes shall be removed from the neck region.-\*

13. The post-mortem examination of cattle that have reacted to the tuberculin test shall receive special attention in order to locate all lesions. Use the guide entitled, "Inspection of Tuberculin Reactors," in conducting this phase of post-mortem examination. In addition to the U.S. Retained tag number, the identification of the animal shall be indicated by the reactor tag number.

14. The fact that an animal has reacted to the test for brucellosis does not require special post-mortem technique. It need not be retained nor classed as a suspect unless cause other than the reaction to the brucellosis test requires such action.

15. Washing of carcasses shall be deferred until bruises have been removed and inspection has been accomplished.



Section 310.10(A)

\*-16. When evidence of cysticercosis is found in cattle, the final inspection of retained carcasses shall be as follows:

- a. The external and internal muscles of mastication, the heart, and muscular portion of the diaphragm including its pillars, should be carefully and thoroughly sliced. The peritoneum must be removed prior to incisions into the diaphragm.
- b. The tongue shall be carefully inspected by palpation, and if the presence of cysts in the muscles of this organ is suspected, the tongue shall be thoroughly sliced and all parts closely examined for cysts.
- c. The muscles of the esophagus, the exposed muscles, and cut muscular surfaces of the split carcass shall be examined.
- d. When cysts are found in more than one of the above sites in a carcass, one transverse cut shall be made in each shoulder 2 or 3 inches above the point of the olecranon and extending to the humerus exposing the triceps brachia and an incision shall be made in each round exposing the musculature in cross section.

17. When more than one beef carcass in a "lot" is found to contain tapeworm cysts, the following procedure is required on all carcasses in the lot.

- a. Multiple incising of the interventricular septum, cheeks, hanging tenders, and diaphragm. The peritoneum must be removed prior to incisions into the diaphragm.
- b. This inspection may be done at a later time and/or in an area other than the killing floor provided that adequate control, lighting, and facilities are available.
- c. If available and identified as part of this affected "lot," additional inspection should be made on hearts, tongues, and cheeks of carcasses which passed inspection prior to finding more than one infected cattle carcass in the lot.

18. When there are findings of cysticercosis in a lot, determine the name and address of the owner of the originating premise. This information should be sent to the Slaughter Inspection Division through the Regional Director. The local Animal Health officials shall be notified by preparing and distributing the form ANH-2-11 as directed.

B. Hogs.

1. Inspectors assigned to head inspection are required to inspect hog carcasses to determine whether they have been properly cleaned. The-\*

\*-establishment must properly clean hog carcasses before any opening is made for evisceration or dropping the head. Once opening cuts are made in the carcass, hair, scurf, etc., shall be removed by trimming. Inspectors can assist the management of establishments in assuming their responsibility by pointing out many of the factors that influence satisfactory scalding, dehairing, and cleaning. Some of these factors are water circulation and temperature, number of carcasses, and time carcasses remain in the scalding tub; condition and operation of the dehairing machine, including the water temperature and number of carcasses through the machine. These factors may vary considerably in different installations and with the type of hogs slaughtered; however, when given adequate attention, there should be no difficulty in obtaining satisfactorily cleaned carcasses. The head shall be presented to the head inspector in such a way as to make the cervical lymph nodes readily available for inspection.

2. Sequence of procedures for the cervical inspection of swine.

- a. Observe the back and leading side as the carcass approaches.
- b. Observe the head and cervical muscles.
- c. Incise the left and right mandibular lymph nodes.
- d. Turn the carcass and observe the trailing side and front.\*

3. When necessary to prevent contamination of the carcass or viscera, the rectum must be tied before evisceration. Establishment employees should exercise care to prevent cutting of intestines and stomach. Carcasses contaminated by stomach or intestinal contents or bile must be thoroughly cleaned in a manner acceptable to the inspector before being presented for inspection. Organs must also be cleaned before inspection. Those organs excessively contaminated shall be condemned.

\*- 4. Sequence of procedures for the viscera inspection of swine.

- a. Observe the eviscerated carcass.
- b. Observe the viscera.
- c. Observe the rectum and its associated lymph nodes.
- d. Observe and palpate the spleen.
- e. Observe and palpate the mesenteric lymph node chain.
- f. Palpate the portal lymph nodes.
- g. Palpate and observe the dorsal (curved) surface of the liver. -\*

\*-h. Turn the liver over, observe the ventral (flat) surface of the liver.

i. Palpate the right and left bronchial lymph nodes.

j. Observe and palpate the dorsal (curved) surface of the lungs.

k. Palpate the mediastinal lymph nodes.

l. Turn the lungs over, observe the ventral (flat) surface of the lungs.

m. Observe and palpate the heart.

5. Establishment employees are required to remove the remnants of spermatic cords, abscesses, and bruises that may be present in ham facings, along with remnants of liver, lungs, bruises, wounds, and other abnormalities from the carcass. The external neck stick wound shall be removed from each swine carcass as a part of the slaughtering operation. The internal neck stick wound shall be opened for removal of blood clots.

6. Sequence of procedures for the rail inspection of swine.

a. Observe the external portions of the lead half of the carcass.

b. Observe all cut surfaces.

c. Observe all body cavities (pelvic, abdominal, and thoracic).

d. Observe and palpate the kidneys.

e. Observe the lumbar region.

f. Observe the neck region.

g. Observe the external portions of the trailing half of the carcass. A mirror may be used as an aid in viewing the external portions of swine carcasses on fast kills.

7. An establishment employee must remove all lymph node tissue from the necks of carcasses retained on account of cervical abscesses or tuberculosis. If slight abscessed heads are passed for food, a careful removal of the mandibular and adjacent nodes shall also be required.-\*

8. Inspectors performing the final inspection of hogs retained on account of tuberculosis must examine by incision all important body lymph nodes of such carcasses except as provided in the following:

- a. Incision of the body lymph nodes may be omitted provided careful inspection of the head and viscera show no lesion other than those in the lymph nodes of the head and mesentery.
- b. Incision of the prescapular node may be omitted provided careful inspection shows the prepectoral node and the thoracic pleura to be free of lesions.
- c. Incision of the prefemoral node may be omitted provided an examination of the superficial inguinal, sublumbar, and iliac nodes shows them to be free of lesions.

9. The necks of hog carcasses may be washed after removal of the leaf and scrap fat. The skimmings from the tank receiving the water from neck washing shall not be used for edible purposes.

C. Calves.

1. Calf carcasses shall be cleaned and dressed while they are suspended from an overhead rail.

\*-2. The heads shall be thoroughly washed and the cavities flushed in the same manner as cattle heads. Establishments wishing to save only the tongue from calf heads may do so without skinning the head, provided the nasal cavities are flushed, the suprapharyngeal lymph nodes are exposed for inspection, and the tongues are individually washed.

3. When calf lungs are prepared as edible product, the usual inspection for foreign material in the bronchi shall be given.

4. Sequence of procedures for the cervical inspection of skinned calves.

- a. Observe the external portions of the head.
- b. Incise the right and left suprapharyngeal lymph nodes.

5. Sequence of procedures for the viscera inspection of skinned calves.

- a. Palpate the bronchial and mediastinal lymph nodes.
- b. Palpate and observe the dorsal (curved) surface of the lungs.
- c. Observe and palpate the heart.
- d. Turn the lungs over, observe the ventral (flat) surface of the lungs.
- e. Observe the spleen.-\*



\*- f. Observe and palpate the dorsal (curved) surface of the liver.

g. Turn the liver over, observe the ventral (flat) surface of the liver and palpate the portal lymph nodes.

h. Observe the stomachs and intestines.

6. Sequence of procedures for the rail inspection of skinned calves.

a. Observe all external and cut surfaces.

b. Lift the forelegs and observe the neck and shoulders.

c. Observe the body cavities.

d. Observe and palpate the internal iliac lymph nodes.

e. Observe and palpate the kidneys.

7. Inspection of large calves requires an expanded inspection procedure because their age permits some disease conditions to develop that require incision for detection.

8. When calves are presented for inspection "hide-on," the inspection techniques must include an expanded procedure of palpating the back for grubs and inspecting the hide for contamination.\*

9. The skins of bruised calves and those affected with grubs, lice, and other skin conditions, as well as those found unclean, must be removed as part of the dressing operations at the time of slaughter.

\*- 10. The adequacy of dressing and cooler facilities to accomplish sanitary handling of the carcass' viscera and parts shall be considered when an establishment proposes to dress so-called large calves.

11. The establishment has the responsibility of skinning and handling calf carcasses in a sanitary manner. The establishment shall be required to furnish mechanical means of positively separating unskinned calf carcasses during the dressing and skinning operations if they cannot otherwise prepare the carcass in a sanitary manner. In cases where the establishment handles "hide-on" calf carcasses or cold skins calf carcasses, the operation shall be prohibited if they conduct the procedures in an insanitary manner.\*

12. Calf carcasses skinned after chilling must be examined closely to detect injection lesions, foreign bodies, parasites, bruises, or other pathology. All abnormal tissues detected must be removed. If an injection lesion is detected, the carcass must be retained and samples submitted to the laboratory. To the extent practical, the same procedure will be followed as if the injection site were detected on post-mortem inspection.

D. \*- Sheep and Goats.

1. In order to prevent contamination of heads, scalping operations shall be delayed until the pelt has been loosened from the rest of the carcass. Horns shall be removed at the time of scalping. Nasal and oral cavities shall be flushed before heads are placed on workup tables or in chutes. Overall washing of carcasses shall be accomplished before any openings are made for inspection or evisceration. A transverse incision across the main bile duct shall be made by the eviscerator as part of the dressing operations.

2. Sequence of procedures for the viscera inspection of sheep and goats.

- a. Observe the abdominal viscera and esophagus.
- b. Observe the mesenteric lymph nodes.
- c. Observe the omental fat.
- d. Observe the bile duct and express its contents.
- e. Observe and palpate the liver (both sides).
- f. Observe and palpate the dorsal (curved) surface of the lungs.
- g. Palpate the bronchial and mediastinal lymph nodes.
- h. Observe the ventral (flat) surfaces of the lungs.
- i. Observe and palpate the heart.

3. Sequence of procedures for the rail inspection of sheep and goats.

- a. Observe the external surfaces of the carcass.
- b. Observe the pelvic cavity.
- c. Observe the abdominal cavity.
- d. Observe the spleen.
- e. Observe and palpate the kidneys.
- f. Observe the thoracic cavity.
- g. Palpate the prefemoral lymph nodes.
- h. Palpate the supramammary or superficial inguinal lymph nodes. -\*

\*-i. Palpate the popliteal lymph nodes.

j. Pass hands down the back and sides of the carcass.

NOTE: This procedure may be eliminated when a mirror is present as an aid in rail inspection.

k. Palpate the prescapular lymph nodes.

l. Pass hands over the shoulders and lift the forelegs.

m. Observe the neck, shoulders, and head.-\*

4. Although the exposure and incision of the body nodes are neither necessary nor desirable as a general practice, such procedures shall be followed when efficient palpation fails to establish beyond a reasonable doubt that the nodes are free from lesions of caseous lymphadenitis.

When incision of body nodes is necessary, care should be exercised to leave the nodes in situ and held by natural attachments for final inspection.

\*-5. The veterinarian will make a thorough examination of retained carcasses and viscera. When caseous lymphadenitis is found, the examination shall include palpation and incision if necessary of the prefemoral, superficial inguinal (or supramammary), internal iliac, sublumbar, renal, prepectoral, prescapular and popliteal lymph nodes, and of the kidneys and other nodes if the conditions so indicate.

6. A common condition found seasonally in sheep is sometimes referred to as "wild oats" or "needle grass." When only a few carcasses are affected or the carcasses have only a few lesions of the condition, the foreign material shall be removed as a part of the dressing operations. When larger lots of affected carcasses or ones extensively affected with the condition are encountered, the carcasses may be placed in the cooler for chilling prior to removal of the foreign material. Such carcasses must be segregated and held under circumstances that preclude any possibility of their being released before the foreign material has been removed.-\*

E. Horses.

1. Loose hair can be controlled by spraying the bellies, legs, and feet with water prior to slaughter. Adequate measures shall be taken to prevent contamination of carcasses and viscera with urine. Hide removal shall be accomplished without the carcass contacting the floor or other fixed objects. The evisceration and splitting operation shall be performed in such a manner that the carcass does not contact the floor.

\*-2. Cervical inspection. The head, identified with the carcass by duplicate numbered tags, shall be removed immediately after skinning. All hide and external ear canals shall be excised prior to thorough washing and flushing of the nasal and oral cavities. Following this, the head shall be-\*



\*-placed on the inspection rack. The inspection shall include a general visual examination of the head for cleanliness, palpation of the submaxillary and pharyngeal lymph nodes and guttural pouch with incision of the parts when necessary to determine the nature and extent of any abnormality. Horse tongues shall be examined for tooth lacerations which must be excised. The dark stain frequently seen on the dorsal surface of horse tongues shall be removed by excision. The muscles of mastication need not be incised for examination.-\*

3. Viscera inspection. Palpate the bronchial and mediastinal lymph nodes and lungs and incise when abnormal conditions are found. The heart shall be incised as for cattle and examined for endocarditis and melanosis. Palpate the portal lymph node, liver, and spleen. Examine the liver carefully on both surfaces. Open the bile duct as for cattle in an examination for flukes. The rest of the viscera and body cavities shall be carefully observed for any abnormality. When horse lungs are prepared as edible product, the usual inspection for foreign material in the bronchi shall be given.

\*-4. Rail inspection. Palpate the body lymph nodes and observe the carcass for abnormality. Encysted parasites may be found under the peritoneum on the inner abdominal walls. Prior to splitting the carcass, the spinous processes of the thoracic vertebrae in the withers region shall be removed and this area, as well as the poll, carefully examined for fistula. Removal of the first two cervical vertebrae facilitates inspection of the poll area. Equipment used in splitting or cutting the withers and poll regions shall be sanitized in 180° F. water after each use. The examination for melanosis shall be conducted carefully, giving particular attention to the axillary and subscapular space in white or gray horses or when melanosis is found elsewhere. Obviously, this requires that such areas be exposed to view by removing the overlying tissues (dropping the shoulder). The fat and tissues lining the pelvic cavity shall be given careful attention, especially along the femoral artery in white and gray horses.-\*

F. Viscera Separation.

Since the opportunities for contamination are great, and product is handled at temperatures conducive to bacterial growth, it is important that inspectors of viscera separation operations be especially alert to any condition adversely affecting the prompt, clean handling of warm offal products. The inspector should be thoroughly familiar with both product and handling procedures. It is of paramount importance to discourage excessive accumulation of any unworked product.



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As a guide, various organs and products are listed below by species, along with conditions that require the attention of the inspector:

Beef Products	Condition
Cheeks -----	Contamination, parasites, cysts, eosinophilic myositis
Lips -----	Hair at angle of mouth, sores, tooth cuts, infections, contamination
Tongues -----	Foreign bodies, hair, tonsils, pieces of hide, contamination, hair sores, ulcers, abscesses, actinomycosis
Poll meat -----	Clumps of loose hair, contamination, bruises
Tails -----	Sections of hide, contamination, rectal mucosa, hair
Livers -----	Abscesses, carotenosis, flukes, cirrhosis, echinococcus, sawdust, telangiectasis, miscellaneous parasitic conditions
Lungs -----	All principal bronchi approximating lead pencil size and larger are to be split and examined for ingesta. Abscesses, contamination, parasites, melanosis, miscellaneous infections
Paunches -----	To be emptied without contaminating the outer surface, all surfaces to be thoroughly cleaned, parasites, abscesses
Brains -----	Blood clots, bone splinters
Hearts -----	Cysts, blood clots, eosinophilic myositis
Weasands -----	Cysts, eosinophilic myositis, contamination
Pork Products	
Ham Facings -----	Scar tissue with infection, abscesses, bruises, hair, scurf, contamination, spermatic cords
Hearts -----	To be opened completely and all blood clots removed
Kidneys -----	Cystic kidneys, kidney worms, other abnormalities
Stomachs -----	Contamination, stomach worms. If unsplit, inner and outer surfaces of casings must be presented for inspection
Chitterlings -----	Free from fecal matter and contamination on both sides, nodules, excess fat to be removed, ileocecal valve to be removed. If unsplit, inner and outer surfaces must be presented for inspection
Ruffle Fat -----	Thorn head worm, small pieces of intestine, intestinal contents, lesions
Cheeks -----	Loose hair, teeth marks, broken teeth, sections of ear tubes, pieces of tonsil, rosin
Brains -----	Bone splinters, contamination
*-Feet -----	Interdigital tissue, hair, claws, dehairing machine cuts-*
Spleens -----	Contamination, parasitic conditions, abnormalities
Crown (Bung)	
Fat -----	Hair, sections of genital organs, contamination
Livers -----	Parasitic lesions, abscesses, contamination
Weasand Meat -----	Contamination, parasites, must be split and washed
Ears, Snouts, Lips and Head Fats ---	Hair, bruises, scurf, rosin, rings, ring holes

\* \* \*

Tongues ----- Parts of tonsils, contamination, parasites

Note: Due to the difficulties encountered in the inspection of hog tongues, the following procedures are described in detail:

1. Many hog tongues are lacerated and soiled during and following the dressing operations. The mutilation is caused in large measure by the action of the beaters of the dehairing machine. When this condition exists, all lacerations and punctures in the tongues must be removed by excision. Stained mucous membranes must be removed by scalding. The trimming of tongues and removal of mucous membranes, when required, should be regarded as a part of the dressing operation.

Threadworms are found in tongues of hogs coming from most sections of the country. All hog tongues used as an ingredient in meat food products or shipped from the establishment labeled as "Pork Tongues" shall be scalded and the mucosa removed. This is the only practical method to assure freedom of this parasite in pork products.

Unscalded swine tongues may be shipped from an official establishment providing they are labeled "Unscalded Pork Tongues," but at no time will they be allowed to be used as an edible product in federally inspected establishments until they have been properly scalded and the mucosa removed.

2. The following two methods of inspecting pork tongues for abscesses have been developed:

METHOD NO. 1 - This method is applicable to hog tongues from sows, stags, and boars. An establishment employee should incise through the midline in the ventral surface of the base or fleshy part of the tongue. This incision need not extend through the dorsal surface. After the incision has been made, the entire tongue should be given a very careful and thorough palpation by establishment employees. A tongue found to contain an abscess may be trimmed to remove the abscess if it is encapsulated. The remainder of the tongue may be passed for food if not contaminated in the trimming process.

Inspectors assigned to supervise this part of the viscera separating operation should reinspect a sufficient number of tongues to ascertain that all abscesses are being eliminated. This reinspection should be made while the tongues are warm and should consist of a very careful palpation of each tongue examined.

METHOD NO. 2 - This method is not applicable to tongues from sows, stags, or boars. An establishment employee should carefully palpate each tongue promptly after removal from the hog's head. The disposition of tongues found to contain abscesses should be as described under Method No. 1. The meat inspector supervising this operation should select approximately 10 percent of the tongues that have been passed by establishment employees and reinspect them by thorough and careful palpation while the tongues are warm. If any abscesses are found on reinspection, all tongues prepared previously during

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the day by this method should be given sufficient reinspection including incising as in Method No. 1 if considered necessary to assure that no abscessed tongues are passed for food.

Since the effectiveness of palpation depends on the tissues being pliable, the importance of performing examination by establishment employees and reinspection by meat inspectors before the tongues become chilled and firm must be considered in establishing inspection routines.

### Sheep Products

#### Condition

Tongues -----	Tonsils, lacerations, abscesses, hair sores, contamination, stained tongues to be scalded to remove mucous membranes
Cheeks -----	Ear tubes, contamination, pieces of wool
Livers -----	Parasites, cystic conditions, scar tissue, abscesses, flukes
Caul Fat -----	Bladder worms, nodules, abscesses, contamination
Paunches -----	To be emptied without contaminating the outer surface, surfaces to be thoroughly cleaned, abscesses, parasites
Ruffle Fat -----	Pieces of small intestines, contamination, abscesses, parasites
*-Lungs -----	Nodular parasites, abscesses, melanosis, abdominal tissue, principal bronchi to be split (pencil size and larger) and examined for ingesta-*

### Calf Products

Tongues -----	Tonsils, hair sores, abscesses, foreign bodies
Cheeks -----	Ear tubes, hide, contamination
Lips -----	Sores, hide at angle of mouth, tooth cuts, contamination
Paunches -----	To be handled and inspected similar to cattle paunches
* * *	
Rennets -----	When abomasi of calves are used to produce rennet, they do not need to be thoroughly cleaned; they may be emptied of their contents in an edible products department provided the operation creates no nuisance. The containers should be marked "calf rennets" and "inedible."
Brains -----	Blood clots, bone splinters

Pharmaceutical products should be prepared, collected, and stored in such manner that there will be no interference in the preparation of edible products or the inspection of such products.

\*-310.11 A clean aqueous solution of common salt not exceeding 20° salometer strength may be used at official establishments for wetting cloths prior to their application to dressed carcasses of any species, under the following conditions:-\*





c. Loosen the liver, lungs, and heart so they are one group and can be hooked to the shank, brisket, or thoracic cavity on the intact side with an "S" shaped hook.

K. Any area of the carcass that has been contaminated with pus, dirt, hair, grubs, or a bruised area must be trimmed and removed before washing the carcass prior to chilling. The tissues that have been removed must be identified with the carcass and placed with the inedible abdominal viscera for inspection. When there is evidence of a possible diseased animal, any missing part will be cause for condemnation of the carcass.

L. The tissues, such as the tongue and lymph nodes that become too difficult to palpate after chilling, must be sliced with a knife for a proper examination.

M. The inedible abdominal viscera and all other removed tissues (refer to paragraph K above) should be kept under refrigeration until the time of inspection. If placed in the edible cooler, contamination of the carcasses and edible products and the cooler itself must be prevented.

N. There must be sufficient space between uninspected carcasses to prevent cross-contamination occurring in the cooler. The spacing should also be large enough to provide adequate circulation of cool air to reach all parts of the carcass and the viscera.

\*-310.19 Handling of Edible Cattle and Calf Feet. The following are considered the minimum acceptable procedures for such an operation:

A. The identity of feet intended for edible purposes must be maintained until the carcass from which they came passes inspection.

B. Feet must be individually washed, using acceptable equipment to prevent splash contamination. Accumulation of feet in a common container prior to the initial washing is not acceptable.

C. When edible feet are to be dehaired, at least 1 inch of the exposed joint at the proximal end of each leg must be removed as the final cleaning operation prior to packing.

D. Edible feet shall be packed in properly identified and labeled true containers.-\*



316.16 Calf carcasses with the skin attached, which are shipped from one establishment to another, may be marked at the second establishment (after the skin has been removed) with the receiving establishment's number and inspection legend. This in no way precludes the responsibility, at the originating establishment, for placing legible brands on each quarter of the carcass. Cuts taken from carcasses marked at another official establishment may be branded with the inspection legend and identifying number of the official establishment in which fabrication is done.

316.17

A. More than the required minimum number of marks of inspection may be placed on carcasses, when warranted by local circumstances. Due to variations in local conditions, and in the further processing of the carcass, it is not practical to designate the location and/or the number of brand imprints to be applied on carcasses.

B. The No. 1 brand (1-3/4 inch diameter) shall be used for branding cattle and hog carcasses. The No. 2 brand (1-1/4 inch diameter) shall be used for calf carcasses. The No. 3 brand (3/4 inch diameter) shall be used for sheep and goats, and loins and ribs of pork.

316.18

A. Beef tenderloins should be individually marked with the inspection legend and establishment number before they leave the official establishment.

\*- B. Marks of inspection on individual oxtails may be waived when shipped from official establishments in bulk containers labeled as follows:

1. Product name
2. Inspection legend
3. Weight statement
4. Name and address of packer or distributor

5. Statement concerning necessary handling for preservation of wholesomeness, such as, "Keep Refrigerated," "Keep Frozen," or the like.

Individual tails, distributed as such, should bear an inspection legend with the establishment number, or be enclosed in a fully labeled immediate container.-\*

316.19 Pork stomachs are considered meat byproducts rather than animal casings, even though intended for use as containers of meat food products.

316.20 The use of metal clips or staples to affix labels or tags to meat food products is not permitted because of the possibility of metal inclusion in product.

316.21 Form CP-408-1, properly modified to describe clearly the product transported, may be used to cover the shipment of product to be further processed, as provided for in Section 316.13(a) of the Regulations. This form is to be used in addition to the certification required in Part 325 of the Regulations.

#### Section 316.22

316.22 If not otherwise specified, statements such as, "cereal added," "nonfat dry milk added," "artificially colored," and the like, should be placed on the product, or on material to be attached to the product, in the order in which the additions normally are made in processing the article.

316.23 It is not practical to state specifically the exact size or weight of products customarily sold at retail intact. Factors that must be considered are: Class of product, geographical distribution, customer expectancy, etc.

#### 316.24

A. Branding the word "tender" or any of its derivatives on heated and smoked pork products may be done only at the establishment at which the processing takes place. The product is subjected to sufficient heat to attain an internal temperature of at least 140° F.



B. Use of the term "Cooked," "Fully Cooked," "Thoroughly Cooked," "Ready-to-Eat," or "Ready-to-Serve" on heated and smoked pork product is acceptable only when the processing results in the product exhibiting the usual characteristics of a fully cooked article, such as partial separation of the meat from the bone, easy separation of the tissues, and a cooked color, flavor and texture throughout the product. This usually requires a minimum internal temperature of 148°F. Proposals for the use of these terms should be accompanied with the full description of the process and internal temperature attained when the marking material is submitted for approval.

316.25 \* \* \* (Reserved)

316.26 When tags, tissue strips, brands, and the like are used to apply the list of ingredients, only applicable required markings should be included thereon. However, if nonrequired features are added, then all applicable required labeling features should be shown. To illustrate: If the name of the product is added on a tag bearing the list of ingredients in bologna, that side of the tag bearing the two features should be completed by adding the name and address of the firm.

316.27 The identity of all ingredients through all stages of fabrication of a meat food product must be maintained.

316.28 When cured meats are used as part of a fabricated product for which minimum meat requirements have been established, consideration should be given to the amount of added substances in the cured meat when calculating the formula on the fresh weight basis.

316.29 Smoked meats such as ham or bacon used in fabricated product may be declared as "Smoked Pork," or "Ham," or "Bacon," as the case may be in the list of ingredients. Such declarations will insure the smoked product as included is identified.

316.30 The domestic meat label should be placed on shipping containers enclosing a combination of inspected product and food articles other than meat products.

316.31 If an immediate or true container serves also as a shipping container, the marks of inspection, as well as the other required features, should be applied.

316.32 Markings other than the inspection legend and establishment number, applied to shipping containers by stencils, pencil marks, or in print, may be used with the approval of the Officer in Charge. Such markings must not be

false or misleading. They may be used in addition to required markings but not in lieu thereof.

316.33 Domestic meat labels that have become detached from the shipping container of federally inspected product may be replaced with domestic meat labels of the receiving official establishment to facilitate further shipment after proper identification of the product has been made.

316.34 The marking required on the shipping container of inedible rendered fat need not be submitted to the Technical Services Division for approval.

316.35 Packaged meat of foreign origin which is repackaged under Federal meat inspection shall be identified as to the country of origin on the new package. When meat in carcass form of foreign origin is separated into cuts which normally have an inspection legend, they shall be marked to show the country of origin adjacent to the marks of inspection. Product resulting from usual boning operations in official establishments need not be kept separate from domestic product for identification.

316.36 The carcasses of animals injected with papain shall be marked with the statement "Tendered with Papain." These markings shall be applied in a continuous manner by means of a roller brand along the round, loin, rib, neck, chuck, and foreshank and from the flank region over the flank, plate, rib, and brisket. Imprints of such roller brands should be forwarded for approval if not already approved.

made on product representing a production lot. Samples may also be sent to the laboratory serving your circuit for evaluation, but the detection of contamination should remain an establishment responsibility with the inspector assuring by his own examinations that no visible contaminants are present.

Any lot found to be contaminated with foreign material should be retained and corrective action taken.

318.95 Regular sausage may contain "not more than  $3\frac{1}{2}$  percent cereal, vegetable, starch, starchy vegetable flour, soy flour, soy protein concentrate, nonfat dry milk, calcium reduced skim milk singly or in combination." Isolated soy protein at 2 percent is considered equivalent to  $3\frac{1}{2}$  percent. This is checked during formulation. The quantity used, however, should not exceed that which is appropriate for the "finished product."

To provide a practical and uniform basis for calculating the maximum allowable amount of extenders, the method illustrated by the following examples is to be followed. The calculations are based on maximum allowable added water. Adjustments will not be necessary for normal variations of added water in the finished product.

Example 1: Regular cooked sausage (NFDM  $3\frac{1}{2}$  percent) (Added water 10 percent)

How much NFDM may be added to a batch containing 400 pounds of meat, seasoning and other ingredients excluding ice (water) and extenders?

Procedure: (This example)

400 pounds

1. Find weight of all ingredients without water and extender added.

$400 \div 0.865 = 462.4$

2. Divide answer of Step 1 by 0.865.  
( $100 - 3\frac{1}{2} - 10 = 86\frac{1}{2}$  percent)

$462.4 \times 0.035 = 16.2$

3. Multiply answer of Step 2 by 0.035. Answer is amount permitted if used by itself.

#### Explanation

We will assume that the final weight will include 10 percent (maximum allowable) added water and  $3\frac{1}{2}$  percent NFDM. With this in mind, the 400 pounds represents only  $86\frac{1}{2}$  percent of the finished weight ( $100 - 3\frac{1}{2}$  percent and 10 percent =  $86\frac{1}{2}$  percent.) The allowance for maximum amounts does not introduce error appreciably beyond normal expected error in laboratory analysis.

Stated algebraically: (86.5 percent) x (Finished Weight) = 400 pounds.

Solving for finished weight:

$$0.865 / 400 = 462.4 \text{ pounds}$$

Amount of NFDM =  $3\frac{1}{2}$  percent x 462.4 =  $0.035 \times 462.4 = 16.2$  pounds.

NOTE:

10 percent of 462.4	= 46.2
$3\frac{1}{2}$ percent of 462.4	= 16.2
$86\frac{1}{2}$ percent of 462.4	= 400.0
100 percent	= 462.4 pounds

Example 2: Regular Cooked Sausage (ISP = 2 percent or NFDM = 3.5 percent)  
(Added water 10 percent)

How much NFDM may be used if 4 pounds of ISP are to be added to a batch with an ingredient weight (excluding water and extenders) of 380 pounds?

Explanation

In this example, the 380 pounds represents 88 percent of the finished weight based on an allowable 10 percent added water and 2 percent ISP. ( $100 - 12 = 88$  percent)

To find finished weight based on 2 percent ISP limitation:

$$0.88 / \overline{380} = 431.8 \text{ pounds}$$

The equivalent amount: 2 percent of 431.8 = 8.6 pounds

Since 8.6 is the maximum of ISP but only 4 pounds is to be added:  $8.6 - 4 = 4.6$  pounds of ISP remains that may be added, or an equivalent amount of NFDM.

The equivalent amount of NFDM is:  $\frac{3.5}{2} = 1.75$   $1.75 \times 4.6 = 8.05 = 8.1$

pounds. Therefore, 8.1 pounds of NFDM may be added with 4 pounds of ISP.

Example 3: Franks (Added water 10 percent) (ISP 2 percent or NFDM  $3\frac{1}{2}$  percent)

How much ISP may I add to a batch beginning with 105 pounds of meat, seasoning and other dry ingredients and 2 pounds of NFDM?

Explanation

Since  $3\frac{1}{2}$  percent of the finished weight may be NFDM and 10 percent may be added water, the 105 equals  $100 - 3\frac{1}{2}$  percent =  $86\frac{1}{2}$  percent of the finished weight.

To find the weight of the finished product:

$$0.865 / \overline{105} = 121.4$$

Total allowable NFDM =  $0.035 \times 121.4 = 4.2$  pounds and  $4.2 - 2 = 2.2$  pounds more of NFDM could be added.

Equivalent amount of ISP =  $\frac{2}{3.5} \times 2.2 = 0.57 \times 2.2 = 1.3$  pounds

Answer

1.3 pounds of ISP may be used with 2 pounds of NFDM in this formulation.



NOTE: In this calculation

$$\begin{array}{rcl}
 86\frac{1}{2} \text{ percent of } 121.4 & = & 105.0 \\
 10 \text{ percent of } 121.4 & = & 12.1 \\
 \hline
 3\frac{1}{2} \text{ percent of } 121.4 & = & 4.2 \\
 100 \text{ percent} & = & 121.3
 \end{array}$$

### Explanation

Rounding to the nearest 0.1 caused the total to be 121.3 instead of 121.4. Take note also, that we added a total of only 3.3 instead of 4.2 pounds "extenders" (2 pounds NFDM + 1.3 pounds of ISP) so that our actual total theoretical weight is  $105.0 + 3.3 + 12.1 = 120.4$  pounds. If this was the actual yield, the added water would be slightly over the 10 percent maximum since  $10 \text{ percent of } 120.4 = 12.0$  instead of 12.1. This much variation is considered normal because of uncontrollable sampling and analytical error.

There may be a few approved formulas for local specialty product that conflict with this instruction. If in doubt, consult your supervisor to determine if such product has been excepted.

### Corn Syrup

Corn syrup solids are permitted in cooked sausage not to exceed 2 percent "calculated on a dry basis." We will consider corn syrup to be 80 percent dry solids.

To determine the maximum amount of corn syrup permitted, calculate the weight of dry solids permitted and convert to weight of syrup.

Example: Product is to contain corn syrup solids and cereal. The weight of the ingredients other than the water, cereal and corn syrup solids is 260 pounds.

Find the maximum amount of corn syrup and cereal permitted in the formulation.

Procedure:  $260 \text{ pounds} = 100 \text{ percent} - 10 \text{ percent} - 3\frac{1}{2} \text{ percent} - 2 \text{ percent}$  or  $84\frac{1}{2} \text{ percent}$  of the finished weight or  $(84.5 \text{ percent}) \times \text{finished weight} = 260$ .

Solving for finished weight:  $\text{Finished weight} = \frac{260}{0.845} = 307.7 \text{ pounds}$

For cereal:  $(0.035) \times 307.7 = 10.8 \text{ pounds}$

For corn syrup solids:  $(0.02) \times 307.7 = 6.2 \text{ pounds}$

For corn syrup:  $6.2 \text{ pounds} = 80 \text{ percent of the weight}$  or  $(80 \text{ percent}) \times \text{corn syrup} = 6.2 \text{ pounds of dry solids}$

Solving for the corn syrup weight:

Answer:  $\text{Corn syrup} = \frac{6.2}{0.80} = 7.75 \text{ pounds}$

Remember that:  $7.75 - 6.2 = 1.55 \text{ pounds of water}$  would be added along with the corn syrup solids.

318.96 The following is permissible in order to inhibit mold growth on dry sausage during drying, storage and transportation.

Potassium sorbate in a 2½ percent water solution may be applied to dry sausage after stuffing and prior to drying. As an alternate procedure, casings may be dipped in a 2½ percent solution of potassium sorbate in water before stuffing.

Sausage treated with the potassium sorbate solution as described above must bear proper branding and labeling, such as "dipped in a potassium sorbate solution to retard mold growth."

318.97 Samples. Microbiology Laboratory.

The following guidelines describe how to obtain and ship samples to laboratories of the Technical Services (TS) Division for microbiological, serological, or antibiotic residue analyses, and how to obtain consultative services.

Perishable Product Samples for microbiological or antibiotic residue analysis that are received in the laboratory in a thawed condition will not be analyzed. Analysis of such samples produces data of no value since the results would not necessarily reflect the original condition of the product.

Tissue Samples for serological analysis (species identification) that are received in the laboratory in a decomposed condition will not be analyzed.

A. CONSULTATIVE SERVICES

1. Meat inspectors may obtain consultative service on microbiological sampling problems by letter or by telephone, if urgent, addressed to Head, Microbiology Group, TS Division. Use of this service will help to assure that samples are taken in such manner, from such sources, and in such numbers that the analysis will produce meaningful data. Data obtained from analysis of samples that are improperly obtained, packed, handled, or shipped are of little value. Some problems may be best solved by reference to reports developed from a study of scientific literature rather than by analysis of samples.

2. Requests for consultative services, except the most routine, shall be handled as follows:

a. Meat inspectors shall obtain prior clearance from the Officer in Charge.

b. The Technical Services Division shall inform the appropriate Division (Livestock Slaughter Inspection Division or Processed Meat Inspection Division) of any in which the Division may have an interest.

B. SAMPLES

1. Sampling Programs

a. Sampling may be prompted either from the field or from Washington, D. C. Inspectors who need bacteriological data



UNITED STATES DEPARTMENT OF AGRICULTURE  
Consumer and Marketing Service  
Consumer Protection Programs  
Washington, D. C. 20250

POULTRY INSPECTORS' HANDBOOK

CHANGE: 16

June 27, 1970

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Labeling for Poultry Products not Amenable to the Poultry Products Inspection Act.

Pigeons, pheasants, quail, and breeds of ducks considered to be wild are excluded from the definition of poultry stated in Section 81.1 (6) of the regulations. These products may be processed at official plants; provided, that such processing does not interfere in any way with inspected poultry processing and the end products are kept adequately segregated. Labels which are not amenable under PPIA may not indicate the official inspection mark unless the official plant operates under the voluntary inspection program.

Labeling for Poultry Products Containing Artificial Coloring

Caramel coloring and the spice "turmeric" may be included in formulas for poultry products: Provided, that they are listed in the ingredients statement on the label for the product. U. S. certified colors and acceptable natural color dyes may be used if the wording "Color Added," "Artificially Colored," or similar wording appears as part of product name; such added color shall be declared in the ingredients statement by name identified as the coloring component.

Articles Labeled not Intended for Human Food, Section 81.147, and Articles for Export for Processing as Human Food

Although all products must be properly labeled prior to shipment from the official plant, it is not necessary for plant management to obtain formal approval of labels for articles "Not Fit for Human Food." It is the responsibility of the inspector-in-charge to approve all labels that do not qualify to bear the official inspection mark including products that require the wording "Not Fit for Human Food," and those products such as feet, heads, and oil glands that are to be shipped to foreign countries to be further processed as human food. Such products as feet, heads, and oil glands that are to be shipped to foreign countries to be further processed as human food do not require being labeled with the words, "Not Fit for Human Food," nor do they require to be denatured or decharacterized if they are collected only from wholesome carcasses and processed and handled in a sanitary manner. All other required labeling information except the official inspection mark must be on these labels. See requirements on exports to Hong Kong.

Special attention must be given to properly decharacterizing such products as gizzards, bones, ova, liver, hearts, and poultry parts that may be separately accumulated for shipment other than for human food. Unless these products meet all minimum requirements of processing and handling required for human food, they must be thoroughly decharacterized by applying one of the following acceptable nontoxic dyes or others which may in the future be approved by the Administrator and properly labeled including the words "Not Fit for Human Food."

- |                                     |                                   |
|-------------------------------------|-----------------------------------|
| 1. Ultramarine Blue Dye             | 4. FD & C Red #2                  |
| 2. Brill Blue FDA or FDC Formula #1 | 5. Great Lakes Brilliant Green #2 |
| 3. FD & C Green #3                  | 6. Great Lakes Brilliant Blue #2  |



The dye used must be in sufficient concentration and amount to render the product thoroughly decharacterized.

All products that are required to be labeled with the words "Not Fit for Human Food," must also be decharacterized with one of the approved dyes.

Bones from a deboning operation which are handled in the same manner as offal need not be denatured or decharacterized.

#### PROTECTIVE COVERINGS FOR POULTRY PRODUCTS

The Act, in Section 8(a), permits reasonable variations and exemptions from labeling requirements. Under this provision, protective covering used on products in multiple unit containers may be exempt from labeling requirements of immediate containers specified in the regulations. Under certain circumstances, some kinds of protective coverings are considered to be immediate containers but under different circumstances they would be regarded only as protection for the product and are not considered to be immediate containers. Those coverings that, because of their usage and location in the distribution system, are regarded as immediate containers must have all of the labeling required in the Act and regulations shown on immediate containers. When protective coverings are not construed to be immediate containers, they are permitted to bear printed information that is appropriate and not misleading.

\* \* \*

Protective coverings such as plastic film bags or cardboard cartons when used to protect poultry that is sold to institutions such as hotels, hospitals, or restaurants, or to the Government or for export are exempt from the mandatory labeling for such containers. However, if for some reason product packed in such containers should be diverted to retail channels and is displayed for sale or sold to household consumers in such containers, it would be in violation of Section 9(a) of the Poultry Products Inspection Act. Such action could result in criminal prosecution of the responsible persons and would result in a requirement that the processing plant involved would place all of the mandatory information on the containers subsequently packaged.

In all instances where protective coverings are used in multiple or single unit packs, the box or case end label for the outside container shall bear the information applicable to immediate containers.

Tray packs are considered to be consumer packages and, therefore, they shall contain labeling applicable to immediate containers. This is required for all consumer packages.





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